Date: User: Tuesday, 23/09/2008 1:00:01 PM

Julie Lecocq

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 42249

Estimate Number

: 12736

P.O. Number

Prsht Rev.

First Issue

Written By

Previous Run

This Issue

: 23/09/2008

: NC

: 11 : 42233 S.O. No. :

: SMALL /MED FAB Type

Part Number

Drawing Name

: D353515

: WEARSHOE

Drawing Number

: D3535 REV B

Project Number

: N/A : B

Drawing Revision Material **Due Date**

: 05/10/2008

Qty:

12 Um:

Each

Checked & Approved By

Comment

New Issue 07-02-15 JLM : Est Rev:A

Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304S20GA

304/316 .040 Sheet



Comment: Qty.:

1.0715 sf(s)/Unit Total:

12.8583 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: 109

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev:_ Prog Rev:__

B 8-11-5

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



B 8-11-5



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

BRAKE NO

NC BRAKE

Comment: NC BRAKE

1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326

2-Form joggle as per Dwg D3535 using Jig DT8158

3-Identify as D3535-15

Dart Aerospace

W/O: WORK ORDER CHANGE										
DATE	STEP	PROC	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	Fault Ca	NC	R: Yes	No DQ	A :	Date:		
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DATE	STEP	Description of NC	Corrective Action			Section B		ation	Approval	Approval
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Tuesday, 23/09/2008 1:00:01 PM Date: User: Julie Lecocq **Process Sheet** Drawing Name: WEARSHOE Customer: CU-DAR001 Dart Helicopters Services Job Number: 42249 Part Number: D353515 Job Number: Seq. #: **Machine Or Operation:** Description: QC5 INSPECT WORK TO CURRENT STEP 6.0 Comment: INSPECT WORK TO CURRENT STEP POWDER COATING 7.0 POWDER COATING **Comment: POWDER COATING** Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 START TIME: **OVEN TEMPERATURE FINISH TIME:** 8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVE Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 9.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 10.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Form: rprocess

Page 2

Dart /	Aeros	pace	Ltd
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Dart Ae	rospace	Ltd							
W/O:		,	V	ORK ORDER CHANG	ES				
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D.4TE	0750	Description of NC	Description of NC		ion B	Verific	ation	1 Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	42249
Description: Wearshoe	Part Number:	D3535-15
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype

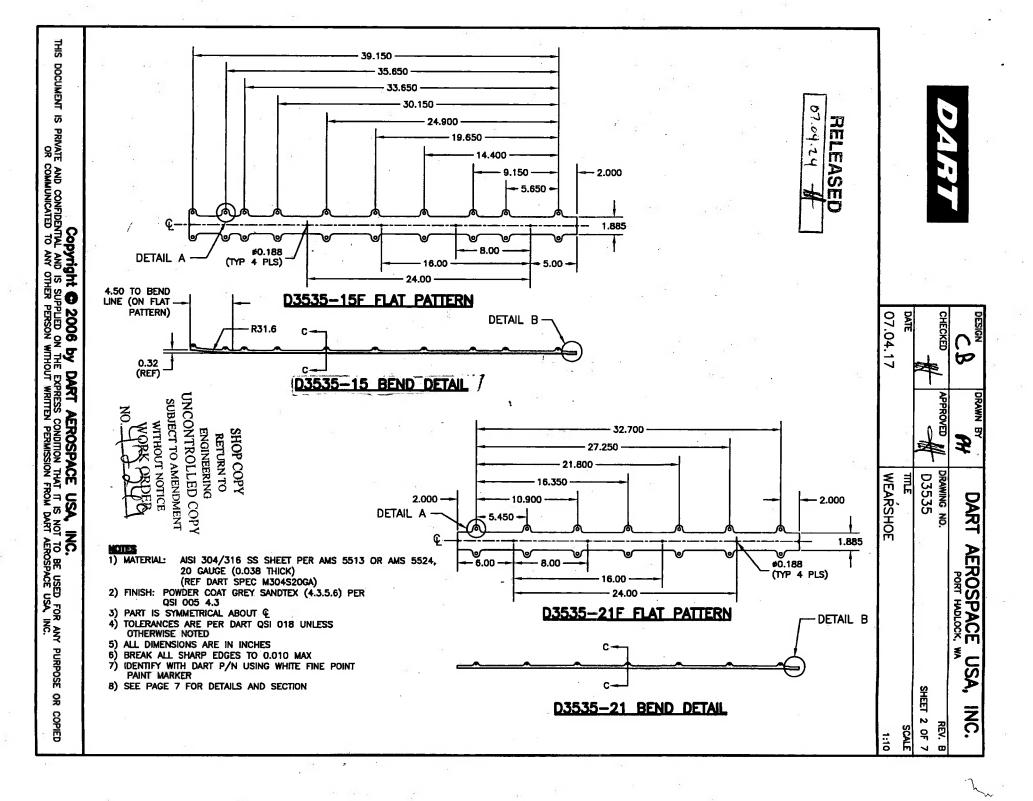
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Date:	8-11-5	Date:	08/11/05	Date:	N/A

Rev	Date	Change	Revised by App	roved
Α	07.05.10	New Issue	KJ/JLM KJ/JLM	2

W/O:		WORK ORDER CHANGES									
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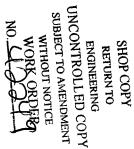
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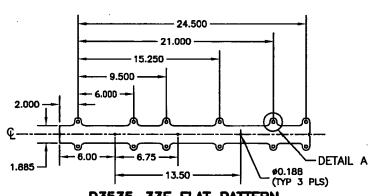
22.500 19.000 14.250 9.500 6.000 2.000 1.885 DETAIL A #0.188 (TYP 3 PLS) D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL



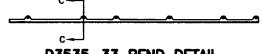
- AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) 1) MATERIAL:
- (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
 3) PART IS SYMMETRICAL ABOUT Q
 4) TOLERANCES ARE PER DART QSI 018 UNLESS DTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- BREAK ALL SHARP EDGES TO 0.010 MAX IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



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RELEASE

D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

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07.04.24 RELEAS

4.750 #0.188 (TYP 2 PLS) -DETAIL A

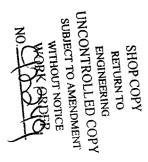
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D3535-35F FLAT PATTERN





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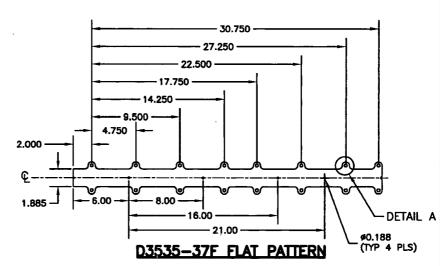
PURPOSE

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1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

- 3) PART IS SYMMETRICAL ABOUT &
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- BREAK ALL SHARP EDGES TO 0.010 MAX
- IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



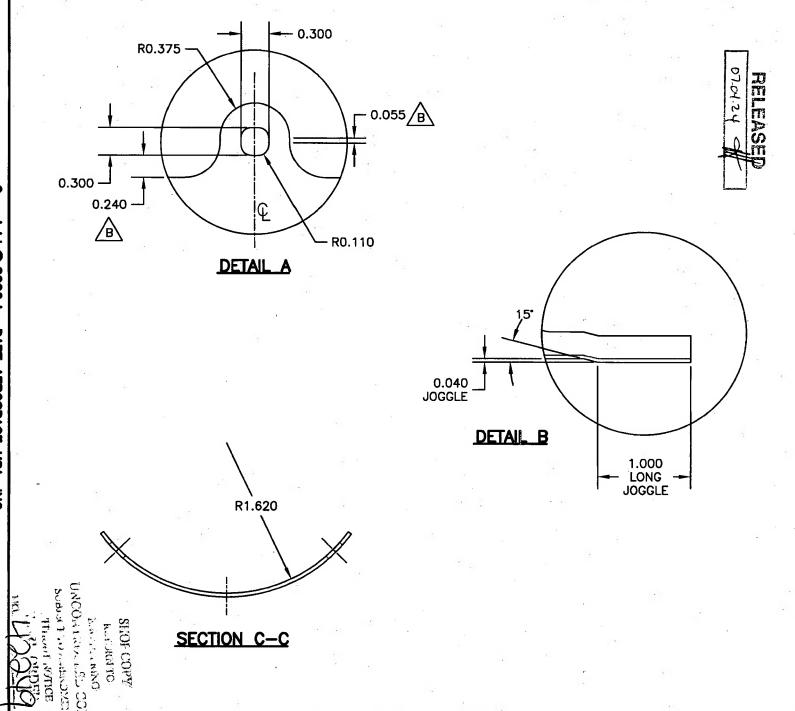


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07.04.17

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